

ASAP

Work Order ID 126585

126585

Page 1

Friday, November 14, 2014 10:52:38 AM

Item ID: 41228-305-003-008 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 11/17/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/21/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 11-11-14 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
41228-305-003	K								

100
 100
 Waterjet
 FLOW CNC Waterjet
 FLOW WATER JET
 Memo
 1-Cut 41228-305-003-010 as per Dwg
 Dwg Rev: K
 Prog Rev: K
 2-Deburr if necessary

110
 110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo

120
 120
 QC
 Quality Control
 QC8- Inspect parts - second check
 Memo

SCRAP

SCRAP RE-PLACED BY
 "D" PART
 11-11-20

(2) 11/11/14
 (2) 11/11/14
 (2) 11/11/14
 14-11-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock, Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
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Work Order ID 126585***126585***

Page 3

Friday, November 14, 2014 10:52:38 AM

Item ID: 41228-305-003-008

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 11/17/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/21/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC14- Inspect Spray Paint

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

Small Fab

Memo

0.00

Small Fab

1- INSTALL NUT PLATE AS PER DWG

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control



DQA: _____ Date: _____



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Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Friday, November 14, 2014 10:52:42 AM

Work Order ID: 126585

126585

Parent Item: 41228-305-003-008

41228-305-003-008

Parent Item Name: Doubler

Start Date: 11/17/14

Required Date: 11/21/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.11.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CCR264SS3-2		Purchased		No			Each	200.0000		8			
CCR264SS3-2									**				
Rivet, Cherry													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST322				200					
				126363				200					
M301S19GA		Purchased		No			sf	52.0000		1			
M301S19GA									**				
301 SS SHEET 1/2 HARD (.040)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				waterjet				52					
				M130453				52					
MS21059L3		Purchased		No			Each	399.0000		4			
MS21059L3									**				
Nut Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				11					
				M129682				11					
				ST303				388					
				M129934				68					
				M130823				320					

Dec 14/11/18

.3819

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DART AEROSPACE LTD	Work Order:	126584
Description: Top Plate Doubler	Part Number:	41228-305-008
Inspection Dwg: 41228-305 Rev: K		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

DAS		DAS		DAS	
Measured by:	DA / 50	Audited by:	30	Preliminary Approval:	
Date:	14/11/98	Date:	9-89	Date:	
			NOV 18 2014		

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

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NOTES:

- 1 WELD IN ACCORDANCE WITH ERA PROCESS SPECIFICATION No. 4001.
- 2 CANCELLED
- 3 PRIME PER ERA P.S. 4004 USING MIL-P-53022B OR 23377 PRIMER.
- 4 CONTOURS TO MATCH MASTER PATTERN 41228-305-003-003 M.P. & 41228-305-003-004 M.P.
- 5 MATERIAL: 301 SS 1/2 HARD QQ-A-766.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	ADDED TOP VIEW, ADDED NOTE 2 & 3, CHANGED MATERIAL FROM 3024 TO 6051.	08-27-93	
B	ADDED NOTE 4	10-29-93	
C	CHANGED RADIUS OF CAVITY EXTENSION	11-05-93	
D	GENERAL UPDATE & ADDED -007 BACK PLATE & -008 TOP PLATE TO L/R & F/R ON SHI 4	11-22-93	
E	GENERAL UPDATE & CHANGED MATERIAL ON -007 TOP PLATE & -008 BACK PLATE	12-01-93	
F	GENERAL UPDATE & CHANGED MATERIAL	02-24-94	
G	REVISED -008 TOP PLATE & -007 BACK PLATE ADDED NUT PLATES & RIVET P/N TO F/R & L/R	05-24-94	
H	GENERAL UPDATE, REMOVED -006 EXTENSION, CHANGED STOCK SIZE ON -003 & -004 CAVITY	12-22-94	
I	INCORPORATED E.O. 1-1	12-15-95	P.SCHWARTZ
J	INCORPORATED E.O. 62965	10-05-10	P.BRAVO
K	INCORPORATED E.O. 63007 & 63104	05-10-11	P.BRAVO

1	7	41228-305-003-011	TOP PLATE		
1	6	41228-305-003-010	BACK PLATE		
12	4	601.3163	RIVET	CCR264SS-3-1	
6	2	MS21059L3	NUT PLATE		
1	1	41228-305-003-005	EXTENSION		
1	2	41228-305-003-004	CAVITY		
1	1	41228-305-003-003	CAVITY		
		41228-305-003-012	CAVITY ASSY		
		41228-305-003-009	CAVITY ASSY		
		41228-305-003-008	BACK PLATE ASSY		
		41228-305-003-007	TOP PLATE ASSY		
		41228-305-003-002	ASSY		
		41228-305-003-001	ASSY		
-012	-008	-007	-002	-001	FIND No.
QTY REQ'D		PART No.		DESCRIPTION	MAT'L SPEC
PARTS LIST					
NEXT ASSY(S)			ORIGINAL DATE 07-13-93 (DD-MM-YY)		
41228-305-005-001			DRAWN BY T. HANVILLE		
41228-305-005-002			DRAWING APPROVAL		
			CONTRACT No.		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES UNLESS OTHERWISE SPECIFIED		
			FRACTIONS 1/16" & 3/16" DECIMALS 0.001" & 0.002"		
			ANGLES 3°		
			SCALE NONE		
			SHEET 1 of 6		

APICAL INDUSTRIES, INC.

CAVITY ASSY AFT ATTACHMENT

41228-305-003

REV K

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41228-305-003-008
TOP PLATE ASSY
TO BE ATTACHED TO CAVITY UPON
INSTALLATION

LUG MOUNTING HOLES
TO BE DRILLED UPON
INSTALLATION

41228-305-003-007
BACK PLATE ASSY
TO BE ATTACHED TO CAVITY UPON
INSTALLATION

CAVITY EXTENSION
41228-305-003-005

.218 DIA. HOLE TYP.
20 PLCS. HOLES TO BE
DRILLED UPON INSTALLATION
USING A/C FOR TEMPLATE.

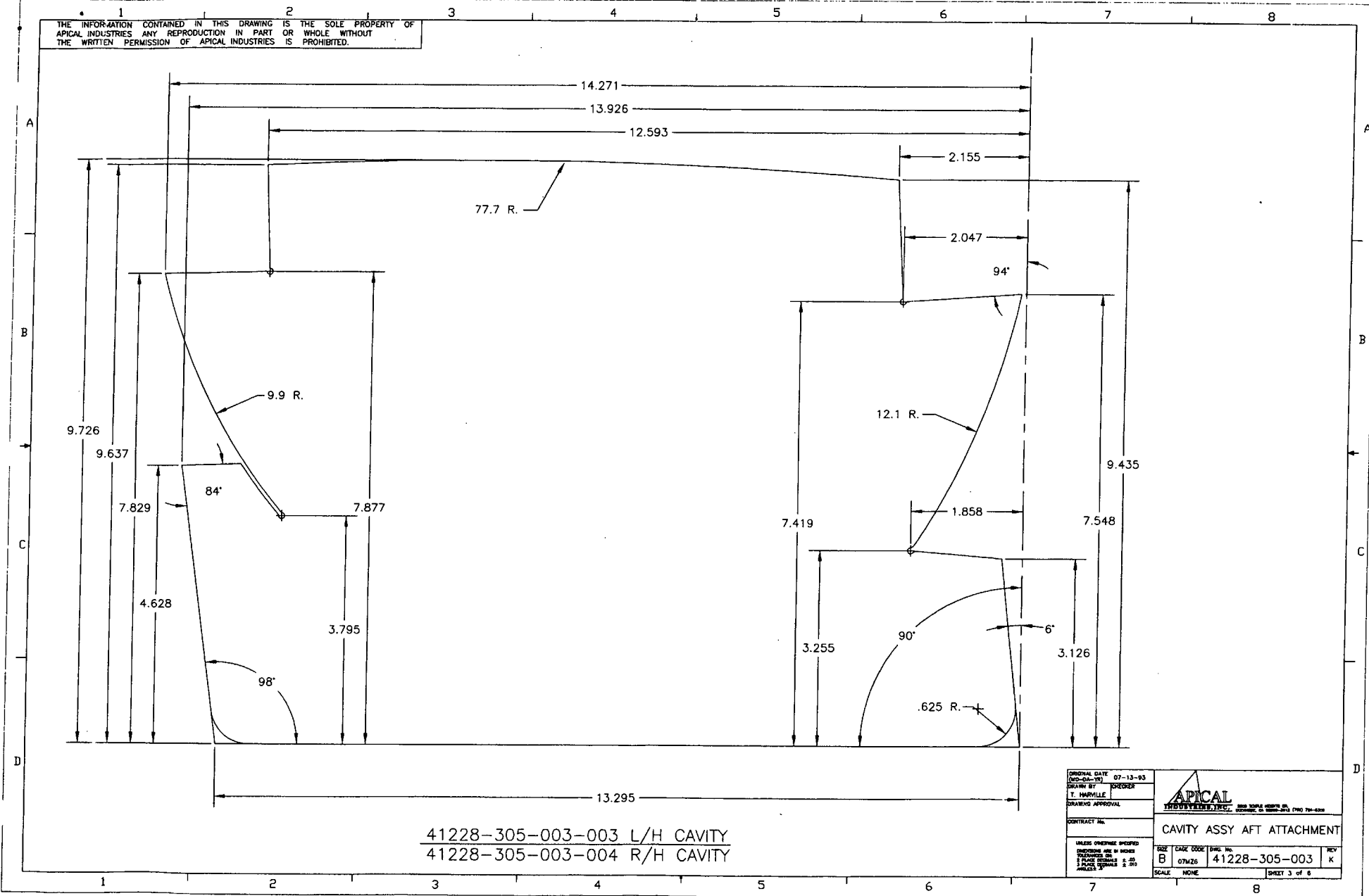
41228-305-003-001 L/H ASSY (SHOWN)
41228-305-003-002 R/H ASSY (OPPOSITE)

41228-305-003-003
L/H CAVITY (SHOWN)
41228-305-003-004
R/H CAVITY (OPPOSITE)

ORIGINAL DATE 07-13-83 (WD-DA-15)		DESIGNED BY T. HARVILLE	
DRAWING APPROVAL		CHECKED BY	
CONTRACT NO.		CAGE CODE 41228-305-003	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS FRACTIONS DECIMALS FRACTIONS DECIMALS		SCALE NONE	
SHEET 2 of 6		REV K	

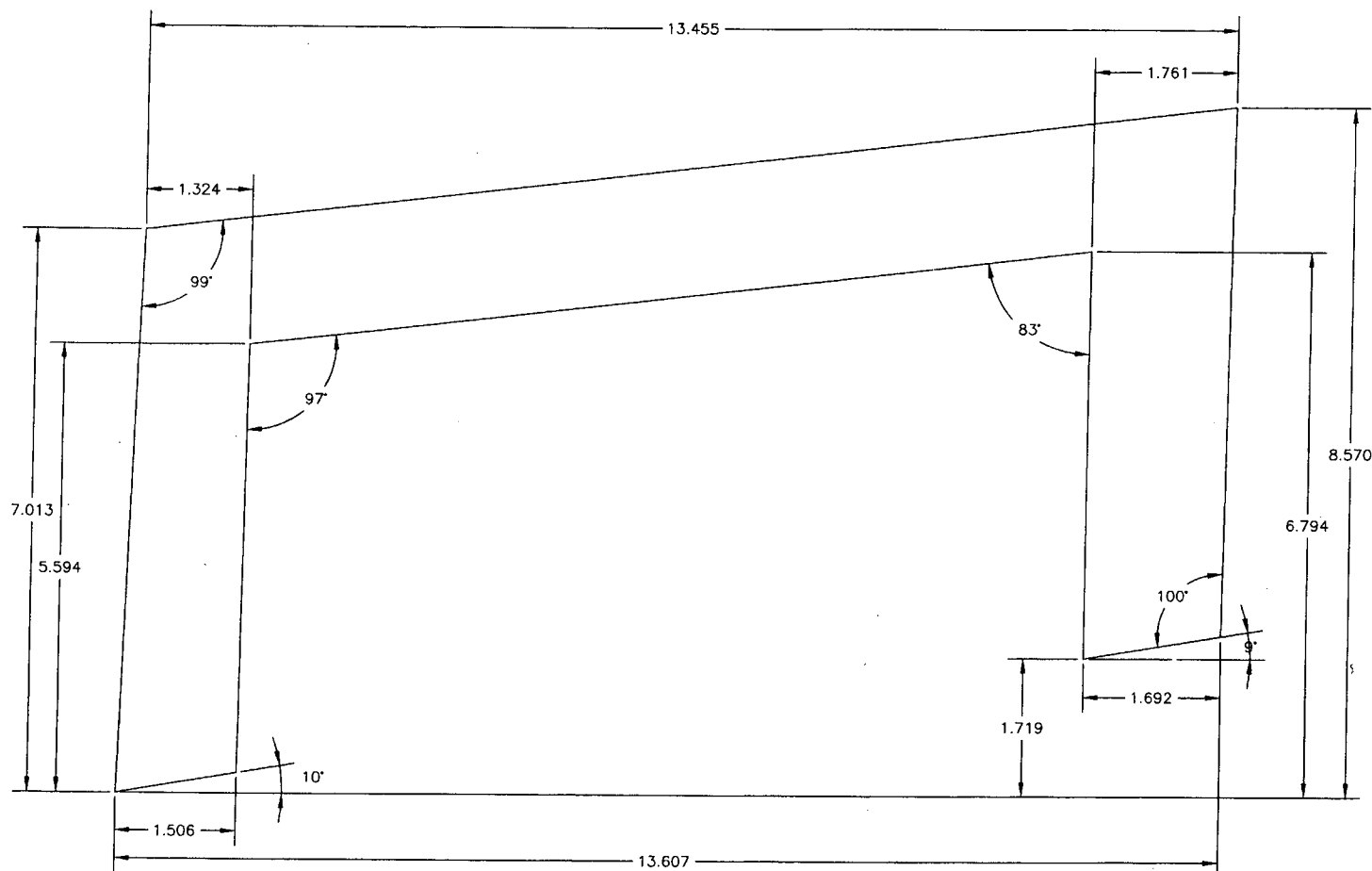
APICAL INDUSTRIES, INC.	
CAVITY ASSY AFT ATTACHMENT	
SIZE B	REV K
SHEET 2 of 6	

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ORIGINAL DATE (MO-DA-YR) 07-13-93		DRAWN BY T. HAYVILLE	
DRAWING APPROVAL		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 1 PLACE DECIMALS ± .05 2 PLACE DECIMALS ± .01 ANGLES ± .1°		SIZE B	SCALE NONE
CAGE CODE 07M26		DWG. NO. 41228-305-003	REV K
APICAL INDUSTRIES, INC.		CAVITY ASSY AFT ATTACHMENT	
SHEET 3 of 6			

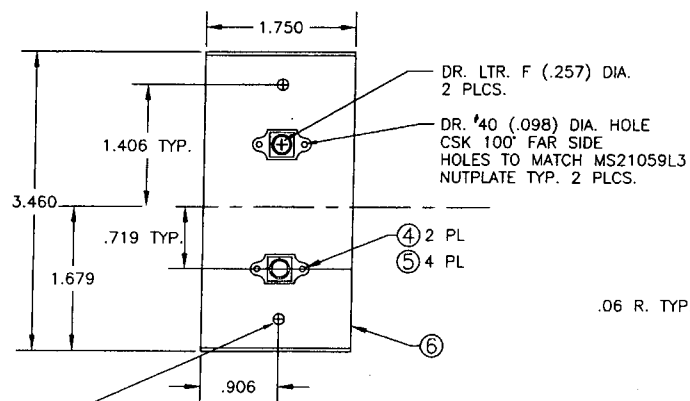
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41228-305-003-005
EXTENSION

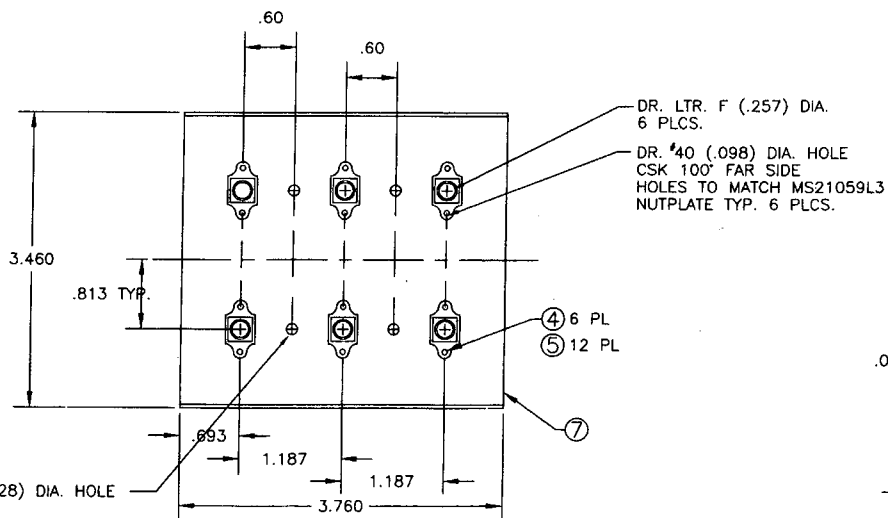
ORIGINAL DATE (DD-MN-YY)	07-13-83	 <small>APICAL INDUSTRIES, INC. 1000 N. 10TH AVE. SUITE 200-200 CHICAGO, IL 60642-1000</small>
DRAWN BY	CHECKER T. HANVILLE	
DRAWING APPROVAL		CAVITY ASSY AFT ATTACHMENT
CONTRACT NO.		
<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. FRACTIONS ± .005 2. DECIMALS ± .001 3. ANGLES ± .01°</small>		SIZE CASE CODE DWG. NO. B 07426 41228-305-003 SCALE NONE SHEET 4 OF 6

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DR. #30 (.128) DIA. HOLE
2 PLCS.

41228-305-003-008 BACK PLATE ASSY



DR. #30 (.128) DIA. HOLE
4 PLCS.

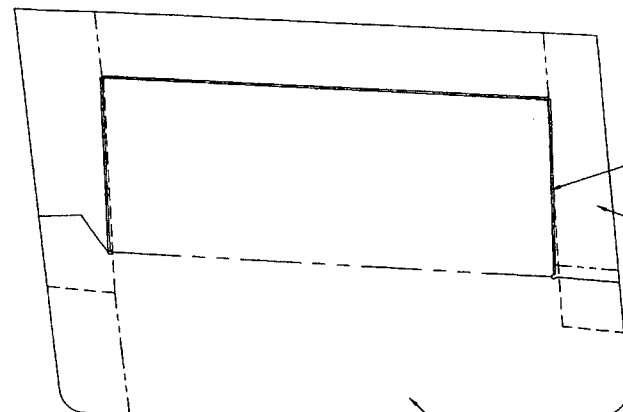
41228-305-003-007 TOP PLATE ASSY

41228-305-003-010 BACK PLATE

41228-305-003-011 TOP PLATE

ORIGINAL DATE (MO-DAY-YR)	07-13-83	 <small>1000 N. 10TH ST. SUITE 100 MILWAUKEE, WI 53233-1000</small>	CAVITY ASSY AFT ATTACHMENT		
DRAWN BY	T. HARVILLE		SIZE	B	REV
DESIGNED BY			CAGE CODE	07M26	41228-305-003
CONTRACT NO.		SCALE	NONE	SHEET 5 of 8	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

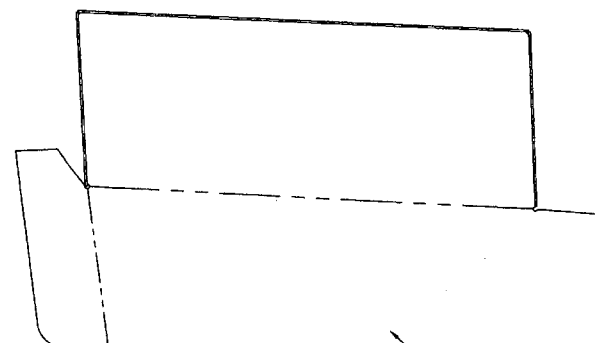


CAVITY EXTENSION
41228-305-003-005


41228-305-003-003
L/H CAVITY (SHOWN)

41228-305-003-009 L/H ASSY (SHOWN)

41228-305-003-012 R/H ASSY (OPPOSITE)



41228-305-003-003
L/H CAVITY (SHOWN)
41228-305-003-004
R/H CAVITY (OPPOSITE)

ORIGINAL DATE (MO-DAY-YR) 07-13-83		 <small>SEE TOP LEFT CORNER OF SHEET FOR APICAL INDUSTRIES, INC. ADDRESS, TEL. (714) 944-4400</small>	
DRAWN BY T. HARVILLE			
DRAWING APPROVAL		CAVITY ASSY AFT ATTACHMENT	
CONTRACT NO.		REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 3 PLACE DECIMALS 2 DIGIT UNLESS NOTED	SIZE B	CAGE CODE 07426	QWC. NO. 41228-305-003
SCALE NONE		SHEET 6 of 6	